

Date: Tuesday, 23/12/2008 3:31:55 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 44329		
Estimate Number	: 10383		
P.O. Number	:	Part Number	: D30661
This Issue	: 23/12/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3066 REV.B
First Issue	: //	Project Number	: N/A
Previous Run	: 43759	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 17/01/2009
Checked & Approved By	: <u>ME 08-12-24</u>	Qty:	60 Um: Each
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:B Now M6061-T6 06-06-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0992 sf(s)/Unit Total: 5.9535 sf(s)
 Material: 6061-T6 0.080" thick
 (M6061T6S.080)
 Batch: 110254 18 9-1-23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3066
 Dwg Rev: B
 Prog Rev: B

18 9-1-23

2-Deburr if necessary

18 9-1-23

(63)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE18 9-1-23

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

090123 (63)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

SL 9-1-24

(63)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 44329

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



63

Comment: INSPECT CHEMICAL CONVERSION COAT

FL 09/01/26

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST237

SS 09/01/26 RGS

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/26 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-01-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

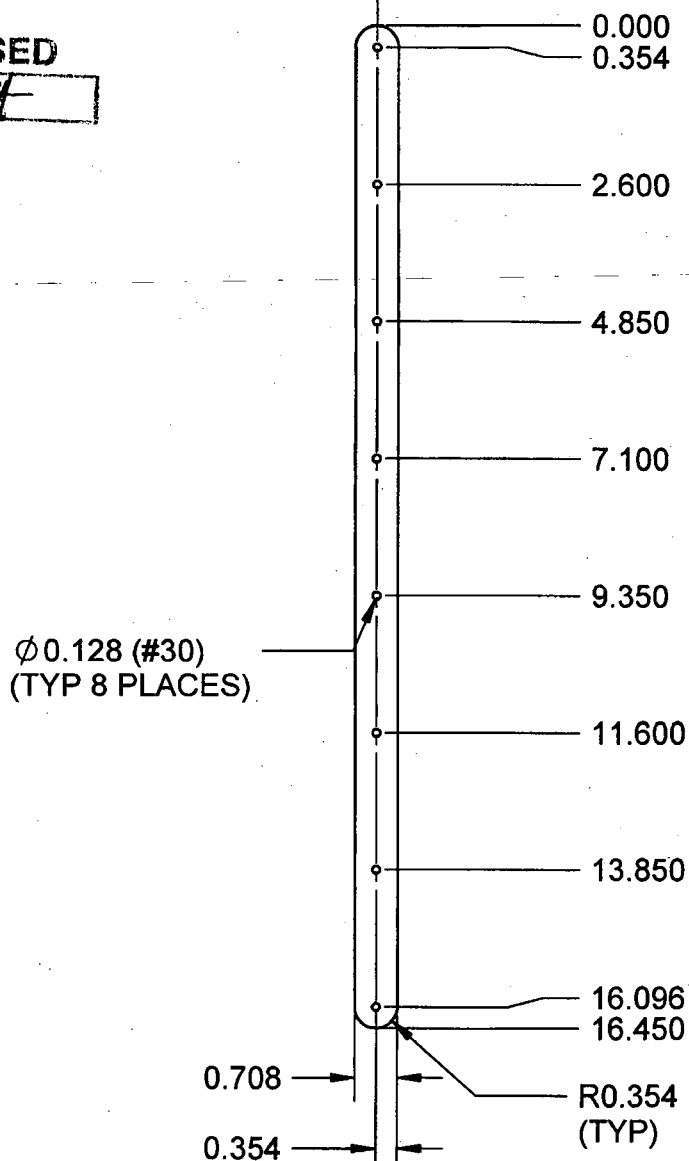
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED
de. de. re



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *44329*

D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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